

# Work Order ID 111468

January-22-14 10:42:26 AM

**\*111468\***

Page 1

Item ID: D206-817-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Screw-In Windshield Modification

Start Date: 1/15/14

Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 1/15/14

Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 14-01-16

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

DSI9659

A

IIN-D206-817

D

*JB*

100

0.00

**\*100\***

DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-817-011 CHG004

DAS

6

9-89

*14/2/10*

*2*

110

Pick Kit

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

*2*

*31*

DAS

33

5-03

*14-01-22*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

104-02-10

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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# Picklist Print

January-22-14 10:42:29 AM

Page 1

Work Order ID: 111468

**\*111468\***

Parent Item: D206-817-011

**\*D206-817-011\***

Parent Item Name: Screw-In Windshield Modification

Start Date: 1/15/14

Required Date: 1/15/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.02.14 NEW ISSUE DD VERF: IPP REV:B  
12.05.09 AS PER IIN REV.C DD VERF:EC IPP REV:C 12.06.12  
ECN 12-602 DD VERF:EC IPP REV:D 13.04.23 as per IIN  
dwg rev.D DD verf:JLM IPP REV:E 13.06.26 as per  
CHG004/DSI9659 DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4541-3 <b>*D4541-3*</b> Bracket	DAS 6	Manufactured	No			110	Each	8.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				DAS 33 9-89	DAS 31 9-89
				st533		8							
					109382	8				109382			
D4541-4 <b>*D4541-4*</b> Bracket	DAS 6 9-89	Manufactured	No			110	Each	9.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				DAS 33 9-89	DAS 31 9-89
				st533		9							
					109484	9				109484			
D4541-5 <b>*D4541-5*</b> Bracket, LH	DAS 6 9-89	Manufactured	No			110	Each	5.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				DAS 33 9-89	DAS 31 9-89
				ST525		5							
					109414	5				109414			
D4541-6 <b>*D4541-6*</b> Bracket, RH	DAS 6 9-89	Manufactured	No			110	Each	5.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				DAS 33 9-89	14-01-22
				ST525		5							
					109436	5				109436			

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

January-22-14 10:42:29 AM

Page 2

Work Order ID: 111468

**\*111468\***

Parent Item: D206-817-011

**\*D206-817-011\***

Parent Item Name: Screw-In Windshield Modification

Start Date: 1/15/14

Required Date: 1/15/14

Start Qty: 2.00

Required Qty: 2.00

D4541-7 Manufactured No

110 Each

4.0000

1 2

DAS  
33  
9-89

**\*D4541-7\***

Bracket

6  
9-89

Location

Loc Qty

Loc Code

ST525

4

103181

3

108237

1

103181

D4541-8 Manufactured No

110 Each

5.0000

1 2

DAS  
33  
9-89

**\*D4541-8\***

Bracket

6  
9-89

Location

Loc Qty

Loc Code

st527A

5

108195

5

108195

D4542-3 Manufactured No

110 Each

0.0000

1 4

DAS  
33  
9-89

**\*D4542-3\***

Retainer, Inner

DAS  
6  
9-89

D4542-5

Manufactured No

110 Each

0.0000

1 4

DAS  
28  
9-89

**\*D4542-5\***

Retainer, Inner

DAS  
6  
9-89

D4542-7

Manufactured No

110 Each

10.0000

1 4

DAS  
33  
9-89

**\*D4542-7\***

Retainer, Inner

DAS  
6  
9-89

Location

Loc Qty

Loc Code

ST532

10

108241

10

108241

DAS  
31  
9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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Page 3

Work Order ID: 111468

**\*111468\***

Parent Item: D206-817-011

**\*D206-817-011\***

Parent Item Name: Screw-In Windshield Modification

Start Date: 1/15/14

Required Date: 1/15/14

Start Qty: 2.00

Required Qty: 2.00

D4543-1  
**\*D4543-1\***  
Retainer, LH Outer (Lower) 9-89

Manufactured No

110 Each

2.0000

\*\*

2

DAS  
33  
9-89

DAS  
31  
9-89

Location

Loc Qty

Loc Code

st526

2

109874

2

109874

2

DAS  
33  
9-89

D4543-2  
**\*D4543-2\***  
Retainer, Outer, RH 9-89

Manufactured No

110 Each

2.0000

\*\*

2

DAS  
31  
9-89

Location

Loc Qty

Loc Code

ST527

2

108221

2

108221

2

DAS  
33  
9-89

D4543-3  
**\*D4543-3\***  
Retainer, Outer, LH 9-89

Manufactured No

110 Each

6.0000

\*\*

2

DAS  
31  
9-89

Location

Loc Qty

Loc Code

ST528

6

110284

6

110284

2

DAS  
33  
9-89

D4543-4  
**\*D4543-4\***  
Retainer, RH Outer (Sloe)

Manufactured No

110 Each

17.0000

\*\*

2

DAS  
31  
9-89

Location

Loc Qty

Loc Code

st529

17

109040

17

109040

14-01-22

January-22-14 10:42:30 AM

Shop Packet Print

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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

January-22-14 10:42:30 AM

Page 4

Work Order ID: 111468

**\*111468\***

Parent Item: D206-817-011

**\*D206-817-011\***

Parent Item Name: Screw-In Windshield Modification

Start Date: 1/15/14

Required Date: 1/15/14

Start Qty: 2.00

Required Qty: 2.00

D4543-5  
**\*D4543-5\***  
Retainer, Outer, LH

Manufactured No

110 Each

17.0000

2

\*\*

DAS  
33  
9-89

DAS  
6  
9-89

Location

Loc Qty

Loc Code

st529

17

101832

13

106315

4

D4543-6  
**\*D4543-6\***  
Retainer, Outer, RH

Manufactured No

110 Each

8.0000

2

\*\*

DAS  
33  
9-89

DAS  
31  
9-89

Location

Loc Qty

Loc Code

st529

8

108205

8

D4544-1  
**\*D4544-1\***  
Retainer, Center

Manufactured No

110 Each

8.0000

2

\*\*

DAS  
33  
9-89

DAS  
31  
9-89

Location

Loc Qty

Loc Code

st530

8

108026

8

D4545-041  
**\*D4545-041\***  
Retainer, LH Inner (Lower)

Manufactured No

110 Each

3.0000

2

\*\*

DAS  
33  
9-89

DAS  
31  
9-89

Location

Loc Qty

Loc Code

ST531

3

108240

3

DAS  
6  
9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

January-22-14 10:42:30 AM

Page 5

Work Order ID: 111468

**\*111468\***

Parent Item: D206-817-011

**\*D206-817-011\***

Parent Item Name: Screw-In Windshield Modification

Start Date: 1/15/14

Required Date: 1/15/14

Start Qty: 2.00

Required Qty: 2.00

D4545-042

Manufactured No

110

Each

6.0000

1 2

**\*D4545-042\***  
Retainer, RH Inner Lower

DAS  
6  
9-89

Location

Loc Qty

Loc Code

ST531

6

109263

6

110

Each

7.0000

\*\*

DAS  
33  
9-89

DAS  
31  
9-89

D4594-1

Manufactured No

**\*D4594-1\***  
Plate

DAS  
6  
9-89

Location

Loc Qty

Loc Code

ST525

7

108028

2

108446

5

110

Each

34.0000

\*\*

DAS  
33  
9-89

DAS  
31  
9-89

D4595-150-13

Manufactured No

**\*D4595-150-13\***  
Sealant Tape (13' Long)

DAS  
6  
9-89

Location

Loc Qty

Loc Code

ST525

34

109875

34

110

Each

1,157.000

\*\*

DAS  
33  
9-89

DAS  
31  
9-89

AN525-10R7

Purchased No

**\*AN525-10R7\***  
SCREW

DAS  
6  
9-89

Location

Loc Qty

Loc Code

ST344

57

m127447

57

ST505

1100

m127815

1100

\*\*

DAS  
33  
9-89

14-01-22

DAS  
31  
9-89

55 X 127447

135 X 127815

January-22-14 10:42:31 AM

Shop Packet Print

Page 5

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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# Picklist Print

January-22-14 10:42:31 AM

Page 6

Work Order ID: 111468

**\*111468\***

Parent Item: D206-817-011

**\*D206-817-011\***

Parent Item Name: Screw-In Windshield Modification

Start Date: 1/15/14

Required Date: 1/15/14

Start Qty: 2.00

Required Qty: 2.00

MS20426AD3-4

Purchased

No

110

Each

11,095.00

112

224

**\*MS20426AD3-4\***

RIVET

DAS  
6  
9-89

Location

Loc Qty

Loc Code

ST334

4000

m127432

4000

ST509

7095

125578

7095

\*\*

DAS  
33  
9-89

DAS  
31  
9-89

MS21059L08

Purchased

No

110

Each

1,158.000

23

46

**\*MS21059L08\***

Nut

DAS  
6  
9-89

Location

Loc Qty

Loc Code

ST508

1158

125654

1158

\*\*

DAS  
33  
9-89

DAS  
31  
9-89

MS21059L3K

Purchased

No

110

Each

1,065.000

56

112

**\*MS21059L3K\***

Nutplate

DAS  
6  
9-89

Location

Loc Qty

Loc Code

GA

257

m127635

257

ST316

808

m127703

808

\*\*

DAS  
33  
9-89

DAS  
31  
9-89

MS21061L08

Purchased

No

110

Each

40.0000

10

20

**\*MS21061L08\***

Nutplate

DAS  
6  
9-89

Location

Loc Qty

Loc Code

ST316

40

m127703

40

\*\*

DAS  
33  
9-89

DAS  
31  
9-89

January-22-14 10:42:31 AM

Shop Packet Print

Page 6

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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# Picklist Print

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Page 7

Work Order ID: 111468

**\*111468\***

Parent Item: D206-817-011

**\*D206-817-011\***

Parent Item Name: Screw-In Windshield Modification

Start Date: 1/15/14

Required Date: 1/15/14

Start Qty: 2.00

Required Qty: 2.00

MS21075L08 Purchased No

110 Each

55.0000

2

**\*MS21075L08\***

ANCHOR NUT

DAS  
33  
9-89

DAS  
31  
9-89

DAS  
6  
9-89

Location

Loc Qty

Loc Code

ST318

55

M126145

55

MS27039-08-10 Purchased No

110 Each

2,310.000

44

**\*MS27039-08-10\***

Screw

DAS  
33  
9-89

DAS  
31  
9-89

DAS  
6  
9-89

Location

Loc Qty

Loc Code

Mezz

6

5865

6

ST307

2304

123100

2029

123265

47

m127430

228

NAS1149DN832J Purchased No

110 Each

3,180.000

44

**\*NAS1149DN832J\***

Washer

DAS  
33  
9-89

DAS  
31  
9-89

DAS  
6  
9-89

Location

Loc Qty

Loc Code

ST293

1000

M127813

1000

st510

376

124555

376

ST510a

1804

M126319

804

M127255

1000

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# DART SERVICE INSTRUCTION

**TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV.2  
OR LATER APPROVED REVISION**

REF. TCCA STC: SH12-3  
REF. FAA STC: SR03091NY  
REF. EASA STC: 10039042

## 1.0 PURPOSE

AT CHG 004 AND SUBSEQUENT, THE D206-817-011 SCREW-IN WINDSHIELD MODIFICATION KIT WILL NOW INCLUDE 2x D4595-150-13 SEALANT TAPE (13' LONG) IN LIEU OF 1x D4595-150-25 SEALANT TAPE (25' LONG) IN ORDER TO AVOID THE EXPIRATION OF UNUSED TAPE SHOULD ONLY ONE REPLACEMENT WINDSHIELD BE NECESSARY.

## 2.0 PARTS LIST

WAS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4595-150-25	SEALANT TAPE (25' LONG)

IS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
2	D4595-150-13	SEALANT TAPE (13' LONG)

## 3.0 INSTALLATION

INSTALL THE D4595-150-13 SEALANT TAPE IN THE SAME WAY AS THE D4595-150-25 SEALANT TAPE PER IIN-D206-817 REV. D OR LATER APPROVED REVISION.

## 4.0 WEIGHT AND BALANCE

THIS CHANGE HAS NO EFFECT ON THE WEIGHT AND BALANCE.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: [Signature]  
D. SHEPHERD (DE # 02)

DATE: 13.06.20  
CERT. NO.: SH12-3  
ISSUE NO.: 1

A	NEW ISSUE	<u>OS</u>	13.06.20
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>OS</u>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>OS</u>		
CHECKED	<u>AD</u>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9659	SHEET 1 OF 1
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	SEALANT TAPE	NTS
DATE	13.06.20	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

111468 MS  
14-01-10

#### 4.0 WEIGHT AND BALANCE

The weight and balance for the D206-817-011 kit is as follows. These are net weights and include the parts removed.

Installation	Weight	LONGITUDINAL	
		Arm	Moment
D206-817-011	2.8 lb	40 in	112 in-lb
Screw-In Windshield Modification Kit	1.3 kg	1.0 m	1.3 m-kg

#### 5.0 PARTS LIST

Qty -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4541-3	BRACKET, LH
1	D4541-4	BRACKET, RH
1	D4541-5	BRACKET, LH
1	D4541-6	BRACKET, RH
1	D4541-7	BRACKET, LH
1	D4541-8	BRACKET, RH
2	D4542-3	RETAINER, INNER
2	D4542-5	RETAINER, INNER
2	D4542-7	RETAINER, INNER
1	D4543-1	RETAINER, LH OUTER (LOWER)
1	D4543-2	RETAINER, RH OUTER (LOWER)
1	D4543-3	RETAINER, LH OUTER (SIDE)
1	D4543-4	RETAINER, RH OUTER (SIDE)
1	D4543-5	RETAINER, LH OUTER (SIDE)
1	D4543-6	RETAINER, RH OUTER (SIDE)
1	D4544-1	RETAINER, CENTER
1	D4545-041	RETAINER, LH INNER (LOWER)
1	D4545-042	RETAINER, RH INNER (LOWER)
1	D4594-1	PLATE
1	D4595-150-25	SEALANT TAPE (25' LONG)
95	AN525-10R7	SCREW
112	MS20426AD3-4	RIVET
23	MS21059L08	NUTPLATE
56	MS21059L3K	NUTPLATE
10	MS21061L08	NUTPLATE
1	MS21075L08	NUTPLATE
22	MS27039-0810	SCREW
22	NAS1149DN832J	WASHER (OR AN960JD8)

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV.2  
OR LATER APPROVED REVISION  
REF. TCCA STC: SH12-3  
REF. FAA STC: SR03091NY  
REF. EASA STC: 10039042

## 1.0 PURPOSE

AT CHG 004 AND SUBSEQUENT, THE D206-817-011 SCREW-IN WINDSHIELD MODIFICATION KIT WILL NOW INCLUDE 2x D4595-150-13 SEALANT TAPE (13' LONG) IN LIEU OF 1x D4595-150-25 SEALANT TAPE (25' LONG) IN ORDER TO AVOID THE EXPIRATION OF UNUSED TAPE SHOULD ONLY ONE REPLACEMENT WINDSHIELD BE NECESSARY.

## 2.0 PARTS LIST

WAS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4595-150-25	SEALANT TAPE (25' LONG)

IS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
2	D4595-150-13	SEALANT TAPE (13' LONG)

## 3.0 INSTALLATION

INSTALL THE D4595-150-13 SEALANT TAPE IN THE SAME WAY AS THE D4595-150-25 SEALANT TAPE PER IIN-D206-817 REV. D OR LATER APPROVED REVISION.

## 4.0 WEIGHT AND BALANCE

THIS CHANGE HAS NO EFFECT ON THE WEIGHT AND BALANCE.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 13.06.20  
CERT. NO.: SH12-3  
ISSUE NO.: 1

A	NEW ISSUE	<u>OS</u>	13.06.20
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>OS</u>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>OS</u>		
CHECKED	<u>140</u>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9659	SHEET 1 OF 1
APPROVED	<u>OS</u>	TITLE	SCALE
DE APPR.	<u>OS</u>	SEALANT TAPE	NTS
DATE	13.06.20	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Work Order ID 111468

\*111468\*

Page 1

January-22-14 10:42:26 AM

Item ID: D206-817-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Screw-In Windshield Modification

Start Date: 1/15/14 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 1/15/14 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan: MLJ Date: 1401-16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
DSI9659	A								
IIN-D206-817	D								
100	DOCUMENT CONTROL	0.00							
<b>*100*</b>									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP D206-817-011 CHG004								
110	Pick Kit,	0.00							
<b>*110*</b>									
Packaging	Memo	0.00							
Packaging									

MLJ 1401-22

